

DQA:

Date: JAN 3 2017

QA Closed

Date:

DEC 19 2016

WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only ☐

Work Order: <u>152229</u> Part No. <u>D2893-1</u> NCR No. <u>16-6177</u>		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☒ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☒</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☒	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
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Date: <u>16-12-07</u>		Step #: <u>100</u>		QTY Effective: <u>20</u>		MRB (QSI042) Approval DAS 12 9-89 <u>16/12/7</u>																																																																	
Description Work Order Deviation <u>top portion of measurement .160"/.125"</u> <u>is .170" (.010" of tolerance)</u> <u>*see drawing for reference*</u> <u>R.C. program.</u>				Disposition <u>acceptable</u> <u>No effect on strength or fit.</u> <u>revised program</u> <u>N/A</u>				Completed By DAS 12 9-89 <u>16/12/7</u> Lead hand / Supervisor Approval Verification DAS 14 9-89 <u>16/12/07</u> QC / QA Coordinator Approval DAS 9 9-89 <u>16-12-07</u>																																																															
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Work Order ID 152229

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152229

Page 2

Item ID: D2893-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Support

Start Date: 10/18/2016 Start Qty: 5.00

5

Cust Item ID:

Required Date: 11/1/2016 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

130

HandFXtube

Memo

0.00

Hand Finishing Crosstubes

Per note 8 on page 1 of dwg D2893, Prep inner concave surface of support and
apply 3M Scotch-Weld as per dwg.
24h of cure time. **134469**

DAS

41

9-89

16-12-8

20

140

140

QC

QC3- Inspect Part Finish

0.00

Quality Control

Memo

0.01

DAS

38

8-89

DEC 09 2016

20

170

170

Packaging

Packaging

Identify as per dwg & Stock Location:

0.00

Memo

0.01

LOCATION : LG050

DAS

6

9-89

DEC 13 2016

20

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WORK ORDER NON-CONFORMANCE / UPDATE



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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Page 3

mf
16-12-13

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Picklist Print

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Page 1

Work Order ID: 152229

152229

Parent Item: D2893-1

D2893-1

Parent Item Name: Support

Start Date: 10/18/2016

Required Date: 11/1/2016

Start Qty: 5.00

Required Qty: 5.00

Comments:

IPP: C02.11.26Reformat; Added P/OKJ

IPP D 06.04.19 removed alodine EC

IPP Rev:E Added priming as per Rev B 07-04-30 JLM

IPP F 08.03.19 Re-format EC verified by: DD

IPP Rev:G 08-05-15 add QC14 DD verified by:EC

IPP Rev:H

11.08.04 as per dwg rev.C DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
DSK078		Manufactured	No			100	Each	15.0000	0.5	3		DAS 33 9-89	
DSK078									**			16/11/28	
D2893-1 Turning Detail													

Location

Loc Qty

Loc Code

MAT060

15

148186

1

149293

2

151098

12

1
2
7

DQA: _____ Date: _____



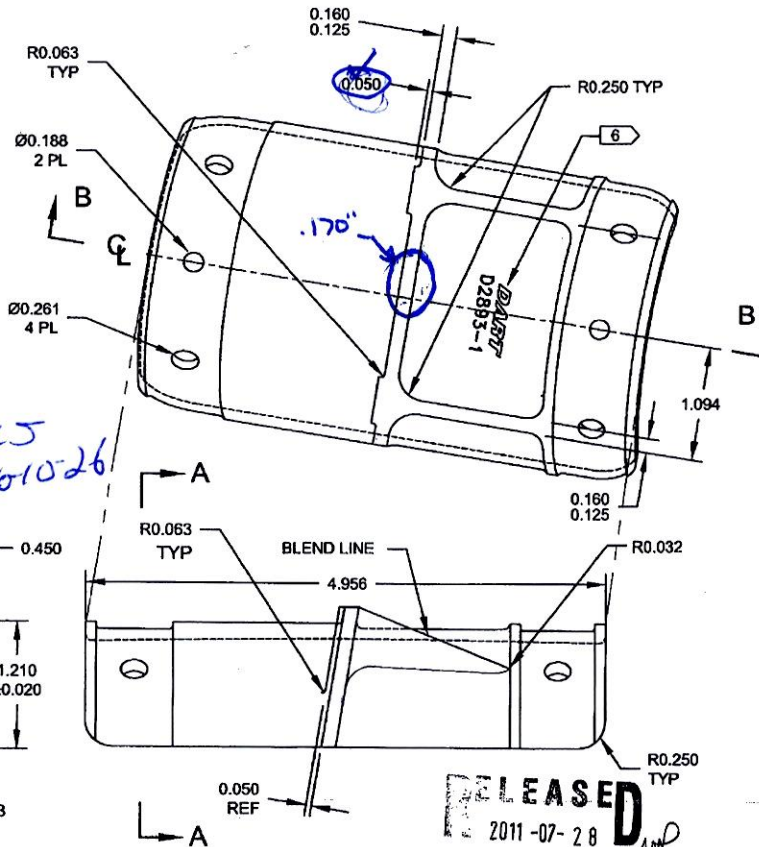
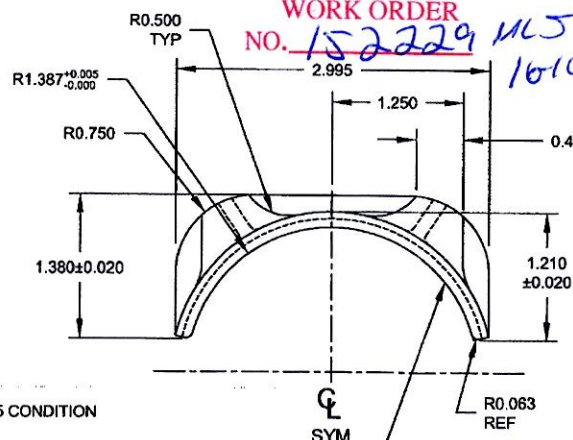
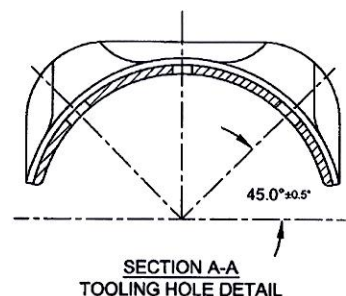
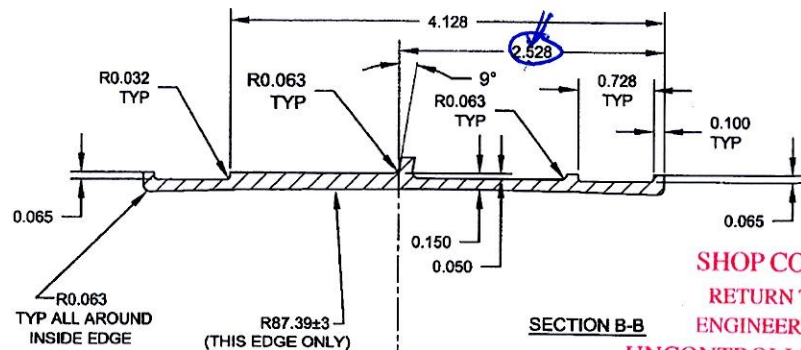
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Root Cause				FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
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Past Expiry Date	☐	Manufacturing Process	☐	OTHER : _____							
Misidentified	☐	Past Due	☐								



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 152229 MJS
101026

D2893-1 SUPPORT

RELEASED
2011-07-28

- NOTES:
- 1) MATERIAL: 17-4 PH STAINLESS STEEL, H900 OR H925 CONDITION
MIN UTS = 170 KSI (38 HRc)
(REF DART SPEC. D6104)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 (REF X.XXX = ±0.010) UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: DART LOGO (PER DART SUPPLIED GRAPHIC) AND PART NUMBER IN THIS AREA WITH 0.125 HIGH LETTERING 0.010-0.020 DEEP, PER DART QSI 044 6.3.
 - 7) WEIGHT: 0.78 lb
 - 8) FOR THE ENTIRE INNER CONCAVE SURFACE:
ABRADE SURFACE WITH 400-GRIT SANDPAPER. REMOVE RESIDUE WITH MEK (OR EQUIVALENT). APPLY 0.03\"

C	RMV FINISH, ADD 3M 2216, ADD H925 MATL OPTION	CP	11.07.15
B	UPDATE DIMS AS MFG, PRIME INSIDE	PH	07.03.16
A	NEW ISSUE	CP	01.01.10
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.07.15		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D2893	REV. C SHEET 1 OF 1
TITLE Ø2.750 SUPPORT	SCALE NTS
COPYRIGHT © 2001 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR LOANED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

DART AEROSPACE LTD		Work Order: 152229
Description: Ø2.750 Support		Part Number: D2893-1
Inspection Dwg: D2893	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	2.985	3.005		2.996	2.996	2.996	2.996	2.995
AB	0.440	0.460		.454	.454	.454	.454	.454
AC	0.125	0.160		.150	.150	.140	.140	.140
AD	0.040	0.060		.050	.050	.050	.050	.050
AE	0.188	0.193		.188	.188	.188	.188	.188
AF	0.125	0.160		.145	.145	.145	.145	.145
AG	0.140	0.160		.152	.155	.154	.154	.154
AH	1.360	1.400		1.376	1.376	1.376	1.377	1.377
AI	0.040	0.060		.054	.047	.052	.053	.053
AJ	1.190	1.230		1.214	1.222	1.217	1.219	1.217
AK	0.010	0.020		.015	.015	.015	.015	.015
AL	0.053	0.073		.063	.063	.063	.063	.063
AM	0.240	0.260		.250	.250	.250	.250	.250
AN	2.518	2.538		2.530	2.530	2.530	2.530	2.530
AO	84.39	90.39		87.39	87.39	87.39	87.39	87.39
AP	0.261	0.266		.261	.261	.261	.261	.261
AQ	0.053	0.073		.063	.063	.063	.063	.063
AR								
AS								
AT								
Accept/Reject				✓	✓	✓	✓	✓

Measured by: JJ DAS	Date: 16-11-29
Audited by: 20 9-89	Date: 16-12-03
Preliminary Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	
C	08.04.21	Reformat	KJ/JLM	
D	12.07.31	Dwg Rev updated	KJ	

DART AEROSPACE LTD		Work Order: 152229
Description: Ø2.750 Support		Part Number: D2893-1
Inspection Dwg: D2893	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	16	17	18	19	10
HAAS Section								
AA	2.985	3.005		2.995	2.994	2.994	2.995	2.993
AB	0.440	0.460		.454	.454	.454	.454	.454
AC	0.125	0.160		.140	.140	.140	.140	.140
AD	0.040	0.060		.050	.050	.050	.050	.050
AE	0.188	0.193		.188	.188	.188	.188	.188
AF	0.125	0.160		.145	.145	.145	.145	.145
AG	0.140	0.160		.150	.147	.148	.144	.148
AH	1.360	1.400		1.377	1.376	1.377	1.376	1.376
AI	0.040	0.060		.054	.053	.054	.054	.053
AJ	1.190	1.230		1.217	1.218	1.220	1.221	1.220
AK	0.010	0.020		.015	.015	.015	.015	.015
AL	0.053	0.073		.063	.063	.063	.063	.063
AM	0.240	0.260		.250	.250	.250	.250	.250
AN	2.518	2.538		2.530	2.530	2.530	2.530	2.530
AO	84.39	90.39		87.39	87.39	87.39	87.39	87.39
AP	0.261	0.266		.261	.261	.261	.261	.261
AQ	0.053	0.073		.063	.063	.063	.063	.063
AR								
AS								
AT								
Accept/Reject				✓	✓	✓	✓	✓

Measured by: SL	Date: 16-11-20
Audited by: DAS	Date: 16-12-03
Preliminary Approval: 20	Date:

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	
C	08.04.21	Reformat	KJ/JLM	
D	12.07.31	Dwg Rev updated	KJ	

DART AEROSPACE LTD		Work Order: 152229
Description: Ø2.750 Support		Part Number: D2893-1
Inspection Dwg: D2893	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	11	12	13	14	15
HAAS Section								
AA	2.985	3.005		2.995	2.992	2.994	2.994	2.995
AB	0.440	0.460		0.454	0.454	0.454	0.454	0.454
AC	0.125	0.160		.140	.140	0.140	0.140	0.140
AD	0.040	0.060		.050	.050	0.050	0.050	0.050
AE	0.188	0.193		.188	.188	0.188	0.188	0.188
AF	0.125	0.160		.145	.145	0.145	0.145	0.145
AG	0.140	0.160		0.155	0.155	0.155	0.155	0.155
AH	1.360	1.400		1.377	1.381	1.382	1.385	1.384
AI	0.040	0.060		0.051	0.048	0.052	0.050	0.048
AJ	1.190	1.230		1.222	1.223	1.225	1.226	1.225
AK	0.010	0.020		.015	.015	0.015	0.015	0.015
AL	0.053	0.073		.063	.063	0.063	0.063	0.063
AM	0.240	0.260		.250	.250	0.250	0.250	0.250
AN	2.518	2.538		2.530	2.530	2.530	2.530	2.530
AO	84.39	90.39		87.39	87.39	87.39	87.39	87.39
AP	0.261	0.266		.261	.261	0.261	0.261	0.261
AQ	0.053	0.073		.063	.063	0.063	0.065	0.065
AR								
AS								
AT								
Accept/Reject				✓	✓	✓	✓	✓

Measured by:	DAS 33 20 9-89	Date:	16/12/01
Audited by:	20 9-89	Date:	16-12-03
Preliminary Approval:		Date:	

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	
C	08.04.21	Reformat	KJ/JLM	
D	12.07.31	Dwg Rev updated	KJ	

DART AEROSPACE LTD		Work Order: 152229
Description: Ø2.750 Support		Part Number: D2893-1
Inspection Dwg: D2893	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	16	17	18	19	20
HAAS Section								
AA	2.985	3.005		2.995	2.995	2.995	2.995	2.995
AB	0.440	0.460		0.454	0.454	0.454	0.454	0.454
AC	0.125	0.160		0.140	0.140	0.140	0.140	0.140
AD	0.040	0.060		0.050	0.050	0.050	0.050	0.050
AE	0.188	0.193		0.188	0.188	0.188	0.188	0.188
AF	0.125	0.160		0.145	0.145	0.145	0.145	0.145
AG	0.140	0.160		0.155	0.155	0.155	0.155	0.155
AH	1.360	1.400		1.384	1.386	1.386	0.048	1.386
AI	0.040	0.060		0.051	0.047	0.048	0.051	0.048
AJ	1.190	1.230		1.222	1.227	1.226	1.228	1.226
AK	0.010	0.020		0.015	0.015	0.015	0.015	0.015
AL	0.053	0.073		0.063	0.063	0.063	0.063	0.063
AM	0.240	0.260		0.250	0.250	0.250	0.250	0.250
AN	2.518	2.538		2.530	2.530	2.530	2.530	2.530
AO	84.39	90.39		87.39	87.39	87.39	87.39	87.39
AP	0.261	0.266		0.261	0.261	0.261	0.261	0.261
AQ	0.053	0.073		0.063	0.063	0.063	0.063	0.063
AR								
AS								
AT								
Accept/Reject				✓	✓	✓	✓	✓

Measured by:	DAS 33	Date:	16/12/02
Audited by:	DAS 20 9-89	Date:	16-12-03
Preliminary Approval:		Date:	

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	
C	08.04.21	Reformat	KJ/JLM	
D	12.07.31	Dwg Rev updated	KJ	